



Dart Aerospace Ltd.
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RBEA62309
Job Sheet 200594



Part No: RBEA62309

Job Qty: 1 pcs

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 11/29/19

Type: Stock

Description: SIOP

Note: DWG RBEA62309 rev.T IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP/IPP Rev.B 19.02.28 drawing revision
DP Verify DD/IPP Rev. C 19.04.01 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Small Fab - Issue SN	1 pcs	11/29/19		0.00	0.00	Small Fab - 1	
							Small Fab - 2	
							Small Fab - 3	
							Small Fab - 4	
							Small Fab - 5	
							Small Fab - 6	GP 19-09-23
							Small Fab - 7	
							Small Fab - 8	
105	Small Fab - 2 - B4B	1 pcs	11/29/19		0.00	2.22	Small Fab - 1 - B4B	
							Small Fab - 2 - B4B	
							Small Fab - 3 - B4B	
							Small Fab - 4 - B4B	
							Small Fab - 5 - B4B	
							Small Fab - 6 - B4B	GP 19-09-25
							Small Fab - 7 - B4B	
							Small Fab - 8 - B4B	
120	QC 5	1 pcs	11/29/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	

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					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130	Packaging 3-1 - Stock - B4B 1 pcs	11/29/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	11/29/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

DAS
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SEP 27 2019
9-89

MD

SEP 30 2019
3-89

RECOIL
A

Part Op 100 - Issue S/N. No labor cost associated with this operation
 Descriptions: 105 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1750-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per drawing.
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1750-E	Pelican Case 1750	1 Ea (1 ea)	100-Small Fab - Issue SN	5204716
5274T761	Polypropylene Vial for Flange Wrench Bolts	48	1 Ea (1 ea)	5120466
7189K31	Cable Ties Black	45	1 Ea (1 ea)	5038430
9052000	10" Mini Bungee Cord	30	4 Ea (4 ea)	5204516
97524A032	Sealing Blind Rivet	40	4 Ea (4 ea)	5163934
NAS1756-12	Remove Before Flight	25	1 Ea (1 ea)	5200859
RB41011	Dart Tooling Placard, Aluminum	140E	1 pcs (1 ea)	5021040
RBE-350DAMPER	Damper Spanner Wrench	144A	1 pcs (1 ea)	5177621
RBE-350HYD	Hydraulic Accumulator Fitting Gauge	144A	1 pcs (1 ea)	5198178
RBE-350INCLINOMETER	Inclinometer	143B.F	1 Ea (1 ea)	5184009
RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	97F	1 pcs (1 ea)	5201720
RBE-350TEMP	Temperature Probe	144A	1 pcs (1 ea)	5186244
RBE350A93-3200-20-1	Main Gear Box/Rotor Brake Retaining Nut Wrench	143	1 pcs (1 ea)	5189200
RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench	143	1 pcs (1 ea)	5184802
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	143	1 pcs (1 ea)	5184770
RBE350A93-3300-20	Tail Rotor Hub Socket	143	1 pcs (1 ea)	5172249
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	143F	1 pcs (1 ea)	5186226
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	143	1 pcs (1 ea)	5186477
RBE350A93-3305-20-1	Tail Gearbox Wrench	143A	1 pcs (1 ea)	5172280
RBE350A93-3307-00	Tail Gearbox Seal Extractor	143A	1 pcs (1 ea)	5188513
RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	143A	1 pcs (1 ea)	5186550
RBE350A93-3316-20-1	Rotating Star Replacement Wrench	143A	1 pcs (1 ea)	5199957
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	143A	1 pcs (1 ea)	5177442
RBE350A93-3400-00	Drive Shaft Thimble	143A	1 pcs (1 ea)	5115898
RBE350A93-3500-00	Bearing Extractor	143B	1 pcs (1 ea)	5186607
RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	143A	1 pcs (1 ea)	5184069
RBE350A94-2704-00	Pedals Locking Tool	141A	1 pcs (1 ea)	5202174
RBE350A94-2706-00	Rigging Pin Set	141A	1 pcs (1 ea)	5197835
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	141A	1 pcs (1 ea)	5191362
RBE350A94-3301-00	Tail Rotor Accelerator Support	14A	1 pcs (1 ea)	5188042
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	141B	1 pcs (1 ea)	5187059
RBE350A94-3700-B	Swashplate Immobilizing Tool, Short Brace Assembly	141B	1 pcs (1 ea)	5214008
RBE350A94-3700-C	Swashplate Immobilizing Tools Adjustable Brace	141B	1 pcs (1 ea)	5183103
RBE350A94-3701-00	M/R Rigging Tool	141B	1 pcs (1 ea)	5196837
RBE350A94-5201-20	Cartridge, Dummy, Fuel	141B	1 pcs (1 ea)	5184179
RBE703A94-1130-01-01	Immobilizing Clip Assembly	137A	1 pcs (1 ea)	5194362
RBE703A94-1130-01-23	Deflection Clip Assembly	133	1 pcs (1 ea)	5194031
RBE703A95-0505-00-15	TGB Drain Tube Quill Assembly	76	1 pcs (1 ea)	5187513
RBE703A95-0508-00-15	MGB Drain Tube Quill Assembly	71	1 pcs (1 ea)	5191040
RBE703A95-0508-00-17	MGB Drain Tube Hose Assembly	71	1 pcs (1 ea)	5181864
RBE703A95-0520-01-17	Engine & Hydraulic Drain Tube Quill Assembly	76	1 pcs (1 ea)	5194491
RBE703A95-0520-01-19	Engine & Hydraulic Drain Tube Hose Assembly	76	1 pcs (1 ea)	5194491
RBEA62309-2	Bottom Cushion use in case APP-1750-E	RB LEFT	1 Ea (1 ea)	5204717
RBEA62309-3	Stiffener Assembly	212	1 pcs (1 ea)	5189245
RBEA62309-6	Top Cushion use in case APP-1750-E		1 Ea (1 ea)	5204718
RBEA62309-7	Top Foam Cushion use in case APP-1750-E		1 Ea (1 ea)	5204719
RBEA62309-8	Top Shelf Placard	135	1 pcs (1 ea)	5198644
RBEA62309-9	Bottom Shelf Placard	135	1 pcs (1 ea)	5198484
RBEA62310	AS350/355 Engine Strut	143F	1 pcs (1 ea)	5196166
RBT18025-13	Linear Scale (50 lbs)	144A	1 Ea (1 ea)	5193255
RBW109-3101-58-1-1	Hammer, Steel	102	1 pcs (1 ea)	5197909
RBW109-3101-58-2-1	Hammer, Aluminum	102	1 pcs (1 ea)	5197081

Job Allocations

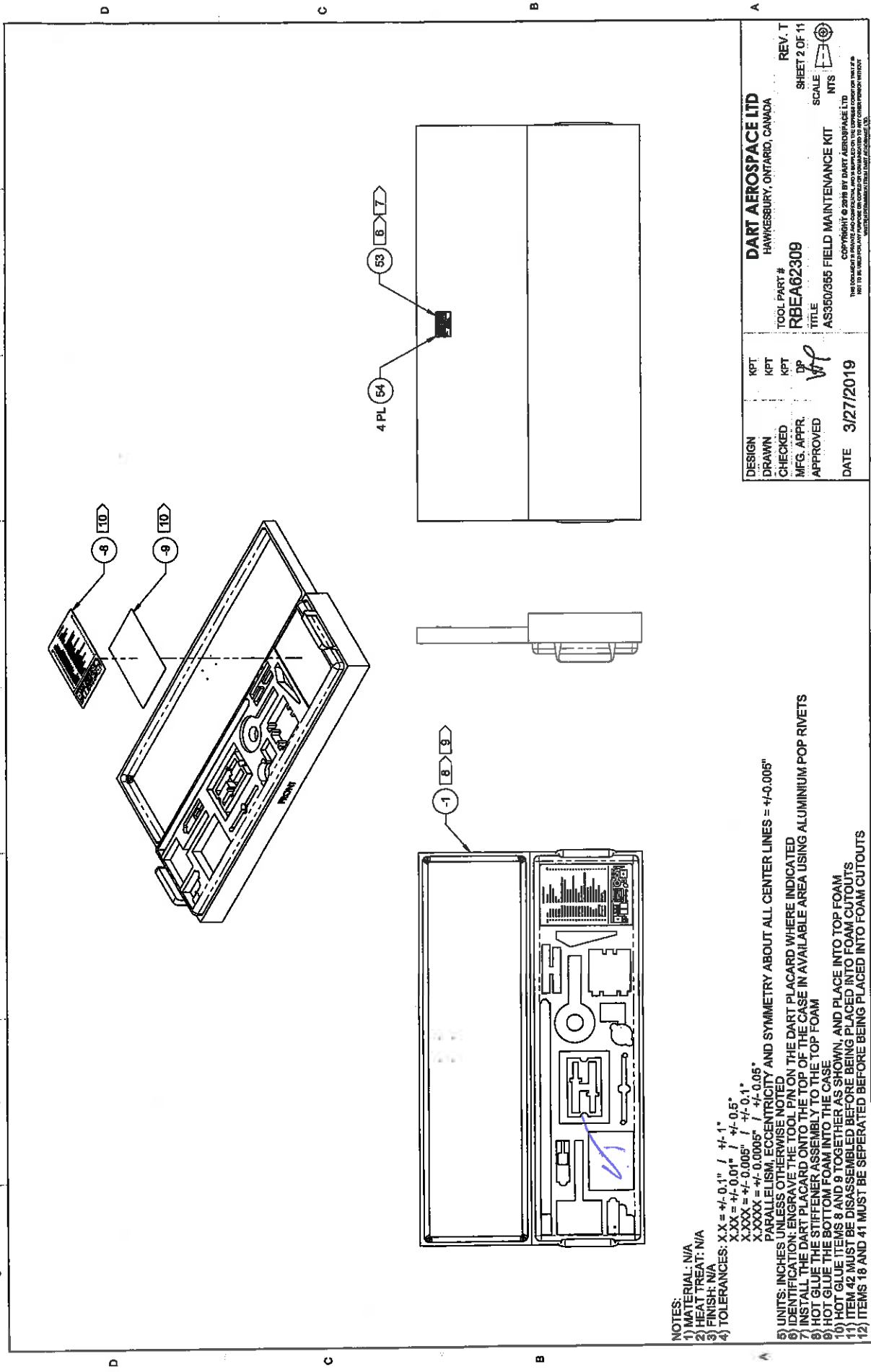
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Issue SN	APP-1750-E	1	9	0
105-Small Fab - 2 - B4B	5274T761	1	9	0
	7189K31	1	744	0
	9052000	4	47	0
	97524A032	4	217	0
	NAS1756-12	1	333	0
	RB41011	1	248	0
	RBE-350DAMPER	1	9	0
	RBE-350HYD	1	12	0
	RBE-350INCLINOMETER	1	11	0
	RBE-350TDRS	1	25	0
	RBE-350TEMP	1	25	0
	RBE350A93-3200-20-1	1	9	0
	RBE350A93-3205-00E	1	10	0
	RBE350A93-3205-00T	1	12	0
	RBE350A93-3300-20	1	7	0
	RBE350A93-3302-02	1	2	0
	RBE350A93-3303-02	1	6	0
	RBE350A93-3305-20-1	1	15	0
	RBE350A93-3307-00	1	3	0
	RBE350A93-3312-03	1	7	0
	RBE350A93-3316-20-1	1	24	0
	RBE350A93-3317-20	1	27	0
	RBE350A93-3400-00	1	26	0
	RBE350A93-3500-00	1	17	0
	RBE350A93-3501-20	1	18	0
	RBE350A94-2704-00	1	13	0
	RBE350A94-2706-00	1	11	0
	RBE350A94-2708-01	1	9	0
	RBE350A94-3301-00	1	26	0
	RBE350A94-3700-A	1	2	0
	RBE350A94-3700-B	1	5	0
	RBE350A94-3700-C	1	1	0
	RBE350A94-3701-00	1	7	0
	RBE350A94-5201-20	1	31	0
	RBE703A94-1130-01-01	1	5	0
	RBE703A94-1130-01-23	1	10	0
	RBE703A95-0505-00-15	1	25	0
	RBE703A95-0508-00-15	1	15	0
	RBE703A95-0508-00-17	1	22	0
	RBE703A95-0520-01-17	1	14	0
	RBE703A95-0520-01-19	1	27	0
	RBEA62309-2	1	9	0
	RBEA62309-3	1	7	0
	RBEA62309-6	1	9	0
	RBEA62309-7	1	9	0
	RBEA62309-8	1	20	0
	RBEA62309-9	1	26	0
	RBEA62310	1	12	0
	RBT18025-13	1	12	0
	RBW109-3101-58-1-1	1	23	0
	RBW109-3101-58-2-1	1	17	0

Part Specifications

Specifications could not be found.

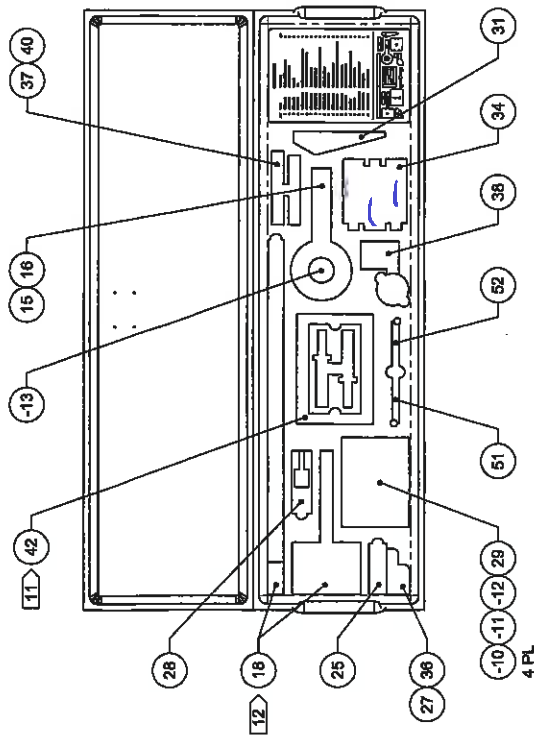
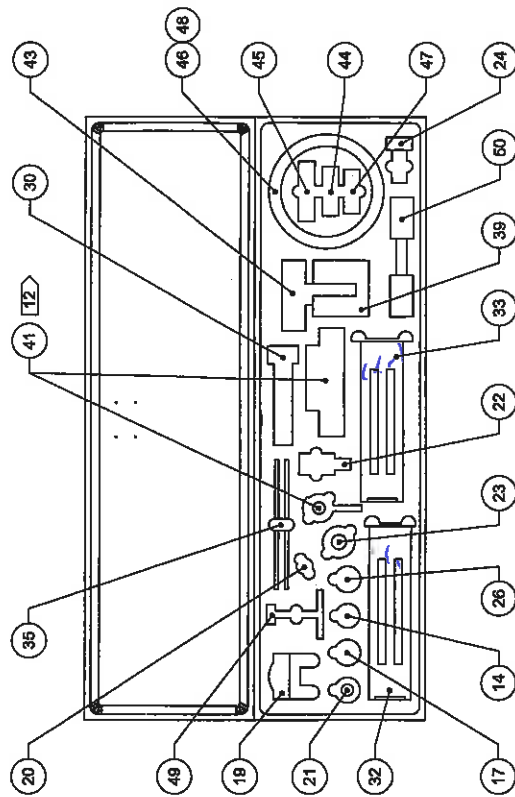
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1 2 3 4 5 6 7 8



DESIGN	KPT	DATE	3/27/2019
DRAWN	KPT		
CHECKED	KPT		
MFG. APPR.	DP		
APPROVED			
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
TOOL PART # RBEA62309			
TITLE AS350/365 FIELD MAINTENANCE KIT			
REV. T SHEET 2 OF 11 SCALE NTS			

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: ENGRAVE THE TOOL PIN ON THE DART PLACARD WHERE INDICATED
 - 7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
 - 8) HOT GLUE THE STIFFENER ASSEMBLY TO THE TOP FOAM
 - 9) HOT GLUE THE BOTTOM FOAM INTO THE CASE
 - 10) HOT GLUE ITEMS 8 AND 9 TOGETHER AS SHOWN, AND PLACE INTO TOP FOAM
 - 11) ITEM 42 MUST BE DISASSEMBLED BEFORE BEING PLACED INTO FOAM CUTOUTS
 - 12) ITEMS 18 AND 41 MUST BE SEPARATED BEFORE BEING PLACED INTO FOAM CUTOUTS



DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

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HAWKESBURY, ONTARIO, CANADA

TOOL PART #

TOOL PART #
RBEA62309

TITLE

TITLE
AS350/355 FIELD MAINTENANCE KIT

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DESIGN	KPT
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DESIGN **DRAWN** **KPI** **KPT**

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APPROVED

APPROVED

DATE 3/27/2019

DESIGN

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DATE 3/2

REV. T
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